

Product Description

The Vibra-Tite 128 is a medium viscosity, thixotropic, anaerobic thread locking adhesive for all types of metal, threaded fasteners. Cured performance features include high vibration resistance, controlled medium strength with good temperature and solvent resistance against water and nonpolar solvents.

Typical Applications

Replaces lock washers and plastic inserts. Locks machine tool access bolts, studs, and hydraulic system bolts. Used on gear box bolts/drive shaft, bearing cover cap screws, counter sunk screws, conveyor roller bolts and construction equipment.

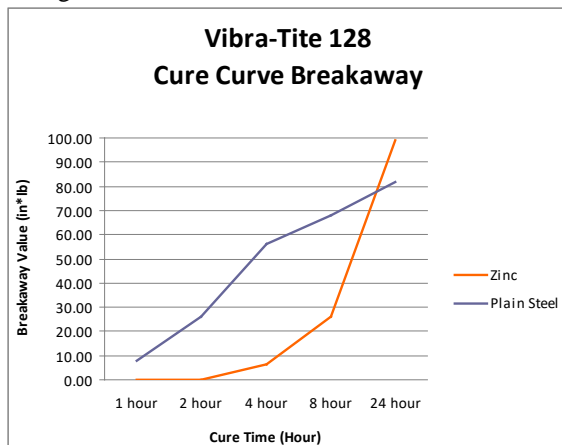
Technical Features

Resin: Methacrylate
 Color: Orange
 Fixture Speed w/Primer: <30 seconds
 Fixture Speed w/o Primer: 120 min @ 77°F
 Viscosity: 1500cPs
 Gap Fill: 0.0015"
 Max. Operating Temp: -60°F to +300°F

Typical Curing Performance

Cure Speed

The cure speed is dependent on temperature and substrate. The graph below shows the Breakaway Strength on 3/8-16 Steel, and Zinc finishes at 77°F



Performance of Cured Material

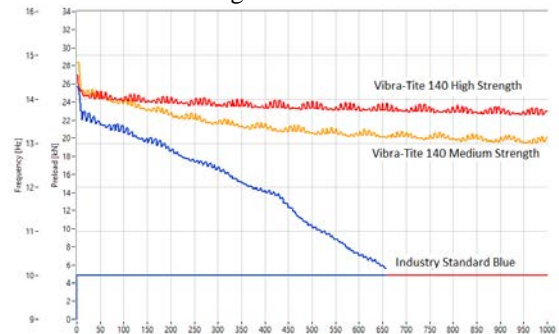
	Typical Values
Full Cure Time	24 hrs @ 72°F
Temperature Range	-60°F to 300°F (-51°C to 150°C)

Breakaway Strength

3/8" Plain Steel nut and bolt @ 24 hr	70-130 lb _F -in
3/8" Zinc nut and bolt @ 24 hr	70-130 lb _F -in

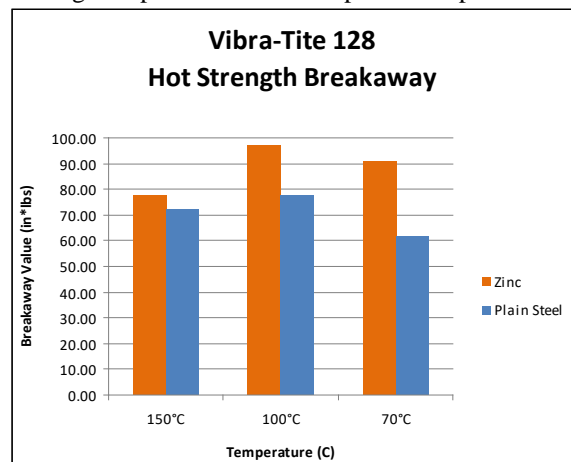
Vibration Resistance

Vibration resistance was performed with a Junkers Vibration tester. Tests were performed with M10 Plain Steel parts. Test parameters were 1000 cycles at 10 Hz. Vibra-Tite 128 was tested against the industry standard medium strength blue threadlocker.



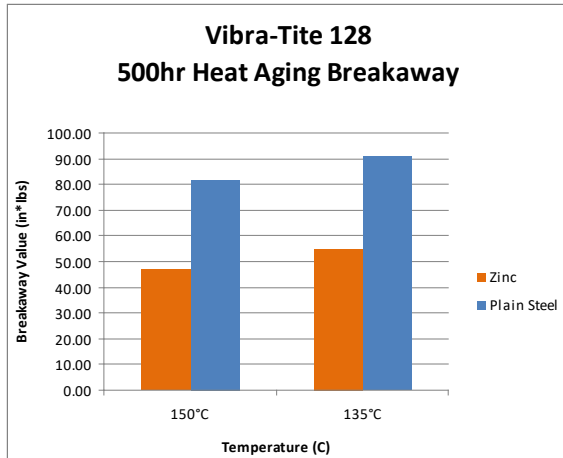
Hot Strength

Vibra-Tite 128 was allowed to cure for 24hrs at room temperature followed by 2hours at temperature. Testing was performed at the reported temperature.



Heat Resistance

Vibra-Tite 128 was allowed to cure for 24hrs at room temperature followed by 500hrs of temperature exposure. Testing was performed at the reported at room temperature.



General Information

Storage

Product should be stored in a cool and dry location at temperatures between 14°F (-10°C) to 86°F (30°C). Shelf life is 2 years from date of manufacture when stored at 72±8°F (22±4°C).

Instructions for Use

Although this threadlocker is oil tolerant, for best performance, clean and dry parts to minimize the amount of surface oil and grease before applying product.

Compatible Primers

Primers such as Vibra-Tite Excel 611 (Primer N) or Excel 612 (Primer T) can be used. The use of primers can result in lower strength and performance should be tested after full cure.

Environmental and Fluid Resistance

Vibra-Tite 128 was allowed to cure for 24hrs at room temperature followed by 500hrs of exposure. Testing was performed at the reported at room temperature

